

Date: Monday, 3/19/2007 8:17:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 31273		
Estimate Number	: 10386		
P.O. Number	: N/A	Part Number	: D31961
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D3196 REVC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 30146	Material	: N/A
Written By	:	Due Date	: 3/23/2007
Checked & Approved By	: <u>John.03.13</u>	Qty:	8 Um: Each
Comment	: Est Rev: A New Issue 05-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 2.2922 f(s)/Unit Total : 18.3372 f(s) 17.4
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
 (M6061T6B0.750x01.500)
 Identify for D3196-1
 Batch: M103156

J.L 07/03/22

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: (0.75" x 1.50") x 26.200" long Bar

J.L 07/03/22

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1

2-Deburr

J.L 07/03/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/03/22

5.0	QC8	SECOND CHECK
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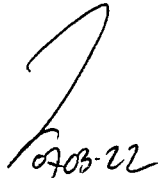
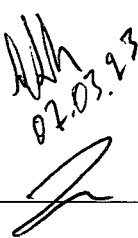

Comment: SECOND CHECK

J.L 07/03/23 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/22	3	- 1 part was short to begin with and is about 19.06-19.07 on overall length & about .020 to .030 under size		Part acceptable	J.L 07/03/22	 07-03-22	 07.03.22	 07-03-22

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

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Part Number: D31961

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(9X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-h

07/03/26

7.0

POWDER COATING

POWDER COATING



9X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h

07/03/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/26 (9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/26 (9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)



Comment: FINAL INSPECTION/W/O RELEASE

07/03/27

Job Completion



U 07.03.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.03.22	N/A	UPDATE DWG WITH SLOT DEAIL AL PER HAND CHANGE ON D3196 REV.C PAGE 1 OF 3.		07.03.22	N/A		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31273
Description: Bar		Part Number:	D3196-1
Inspection Dwg: D3196	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

07.03.19

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	26.094	+/-0.010	26.094	✓		m-tape	
4.045	4.083	+/-0.010	4.047	✓			
18.003	17.928	+/-0.005	18.003	✓		m-tape	
	0.750	+/-0.005	.751	✓			
	1.500	+/-0.010	1.502	✓			
	Ø0.344	+0.006/-0.001	.344	✓			
	Ø0.660 x 100°	+0.008/-0.001 x 0.5°	.660x100°	✓			
	0.060 x 45°	+/-0.010 x 0.5°	.057x45°	✓			
	0.750	+/-0.010	.748	✓			
	0.250	+/-0.010	.249	✓			
3.495	3.583	+/-0.010	3.495	✓			
	9.000	+/-0.010	9.000	✓			
	16.844	+/-0.010	16.844	✓		m-tape	
21.498	21.511	+/-0.010	21.498	✓			
	R0.125	+/-0.010	.125	✓			
1.103	1.000	+/-0.010	1.090	✓			
	R0.125	+/-0.010	.125	✓			
	0.444	+/-0.010	.442	✓			

Measured by:	J.L	Audited by:	MS	Prototype Approval:	N/A
Date:	07/03/22	Date:	07/03/22	Date:	N/A

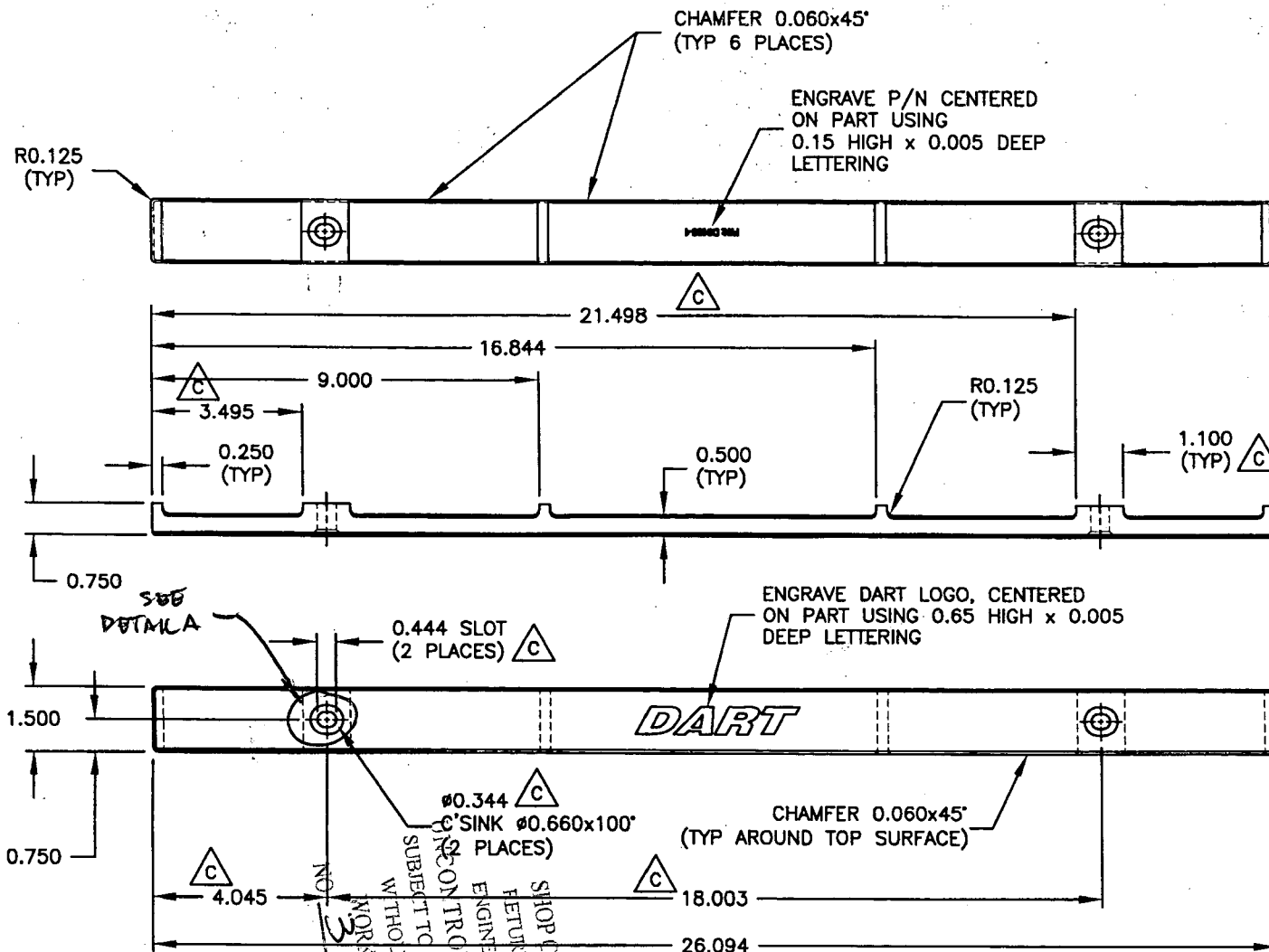
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	

[Handwritten signature]

DART**RELEASED**

06.10.31

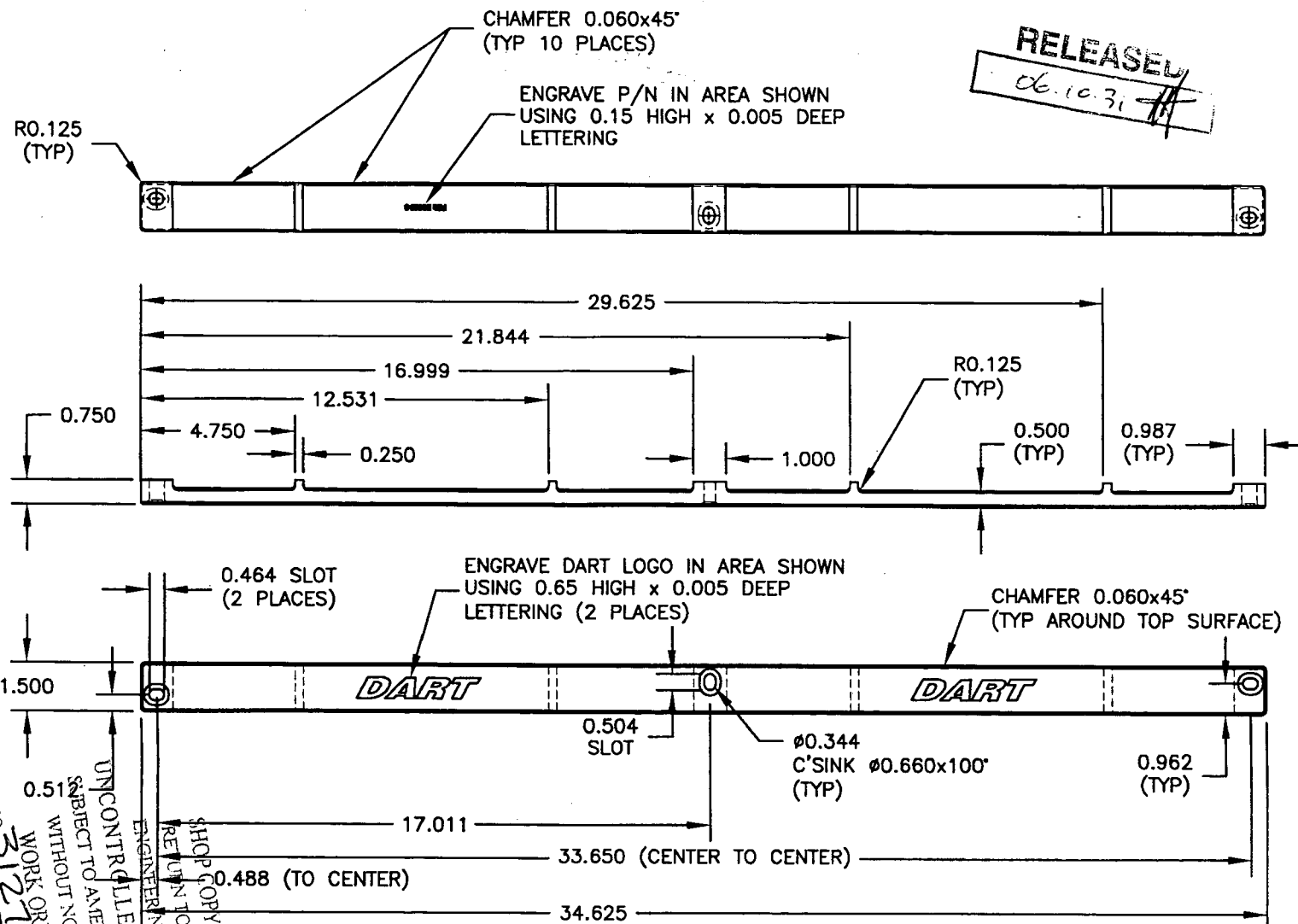
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00		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
06.10.31	06.10.31	D3196	
DATE	TITLE	SCALE	
06.10.31	BAR	1:4	
A	03.06.25	NEW ISSUE	
B	06.09.25	ADD D3196-5	
C	06.10.31	ADD SLOTS ON -1; REMOVED -5	

**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART

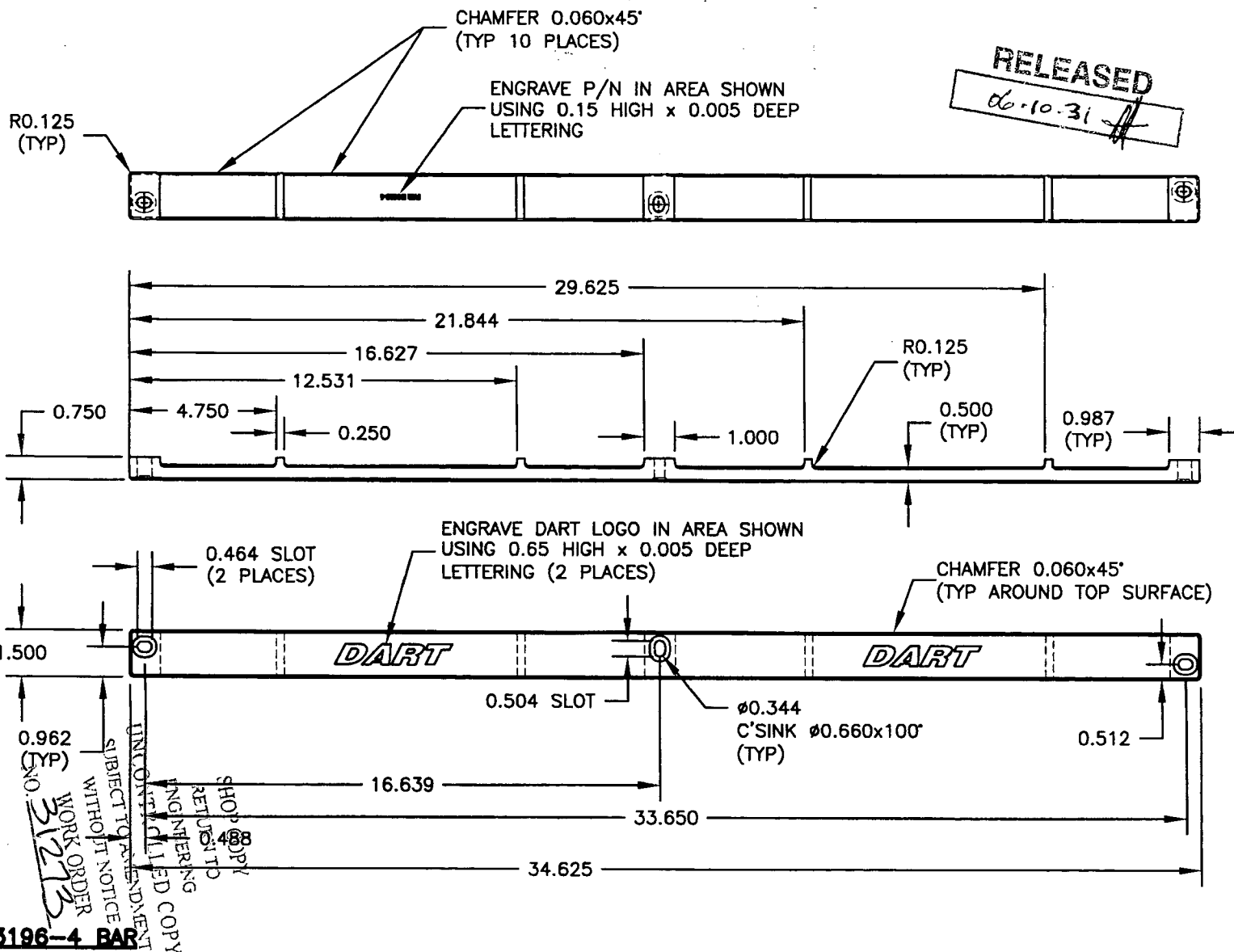
DESIGN	90	DRAWN BY	AS	DART AEROSPACE LTD
CHECKED	AM	APPROVED	AS	HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	DRAWING NO.	D3196	REV. C
		TITLE	BAR	SHEET 2 OF 3
		SCALE	1:5	



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DESIGN	90	DRAWN BY	AS	DART AEROSPACE LTD
CHECKED	PH	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	DRAWING NO.	D3196	REV. C
		TITLE	BAR	SHEET 3 OF 3
		SCALE	1:5	



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